

Work Order ID 67845

Thursday, March 31, 2011 3:48:29 PM



Page 1

Item ID:	D3021-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Tube Assembly					
Start Date:	4/1/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	4/7/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	11-03-31	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3021	Rev A								
100	Large Fab	0.00							
	Large Fab								
Large Fab	Memo	0.00							
	1-Cut tube as per Dwg D3021								
	2-Drill tube as per Dwg D3021 using D8622								
	3-Deburr								
	4-Weld as per Dwg D3021 QSI004								
	A/R 4130 Rod Batch: M100075								
110	QC9- Inspect visual per QSI004- Fusion Welds	0.00							
	QC								
Quality Control	Memo	0.00							

EL 114-20 (21)

1 0 BE11/0/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D3021-041

Accept

Revision ID:

Item Name: Tube Assembly

Start Date: 4/1/2011 Start Qty: 1.00

Required Date: 4/7/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QS1005 4.3

0.00



Powdercoat

Memo

0.00

Powder Coating

START TIME: 12:30
OVEN TEMPERATURE: 400'
FINISH TIME: 1:00

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11 04 21 ①

EJS 11/04/25 ①

W/O:		WORK ORDER CHANGES					
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Thursday, March 31, 2011 3:48:29 PM

Item ID: D3021-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Tube Assembly

Start Date: 4/1/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 4/7/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: GA

0.00



Packaging

Memo

w/o 67840

0.00

Packaging

160

QC21 - Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 67845

Parent Item: D3021-041

Parent Item Name: Tube Assembly



Start Date: 4/1/2011

Required Date: 4/7/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP 01.10.23 New Issue SM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3017-11		Manufactured	No			100	Each	12.0000	2	2			
cap													

Location Loc Qty Loc Code

WA019 12

52583 12

M4130NT0.750W.049		Purchased	No			100	f	85.2300	2.0833	2.192947			
4130 RD Tube .750 x.049W													

Location Loc Qty Loc Code

MAT033 85.23

10133 10.73

110740 74.5

EL 11-4-20

2

EL 11-4-20

2.19

W/O:		WORK ORDER CHANGES					
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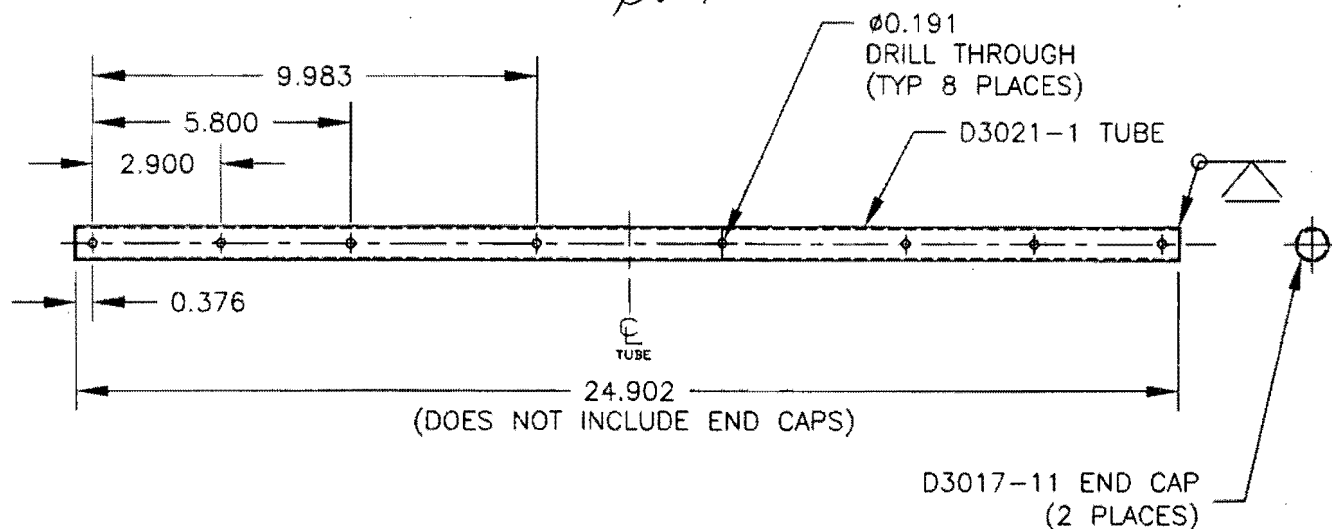
NOTE: Date & initial all entries

DART

DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>#</i>	APPROVED <i>#</i>	DRAWING NO. D3021	REV. A SHEET 1 OF 1
DATE 01.05.18		TITLE TUBE ASSEMBLY	SCALE 1:4
A	01.05.18	NEW ISSUE	

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *67845*

PS 11-03-31



D3021-041 TUBE ASSEMBLY
(D3021-1 TUBE)

NOTES:

- 1) PART IS SYMMETRIC ABOUT CENTERLINE
- 2) MATERIAL: AISI 4130 TUBE, $\phi 0.75$ DIA x 0.049 WALL (M4130N-T0750W049)
- 3) WELD PER DART QSI 004
- 4) FINISH: POWDER COAT GREY SANDTEX (REF 4.3.5.6) PER DART QSI 005 4.3
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

RELEASED
01.05.30

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